





# Work Order ID 77847

**\*77847\***

Page 3

Thursday, December 22, 2011 7:59:57 AM

Item ID: D4571-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: PRELIM Stop **\*NS2\***  
 Item Name: Base  
 Start Date: 12/22/2011 Start Qty: 7.00 **\*7\*** Cust Item ID:  
 Required Date: 12/28/2011 Req'd Qty: 7.00 **\*7\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140	Fire Red(Ref:4.3.5.10) per QSI005 4.3	0.00							
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<b>*140*</b> Powdercoat Powder Coating	Memo START TIME: 12/10 FINISH TIME: 32001- OVEN TEMPERATURE: 1:40	0.00							7x2 m-f 12/04/05
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150	Identify as per dwg & Stock Location: _____	0.00							
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<b>*150*</b> Packaging Packaging	Memo	0.00							SB 12/01/12
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160	QC21- Final Inspection - Work Order Release	0.00							12/11/16
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<b>*160*</b> QC Quality Control	Memo	0.00							
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**POSITIVE RECALL**  
 EFFECTIVE 11/17/12 AUTH ME  
 RELEASED 12.01.16 DATE 12.01.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4571 PAR #: \_\_\_\_\_ Fault Category: Machining NCR: Yes No DQA: OK Date: 12/1/17  
12-1117 Resolution: Rework Disposition: Rework QA: N/C Closed: OK Date: 12/1/17

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/01/10	#150	During Assembly it was found that the hing holes were drilled in the wrong orientation to the part. R.C. h.a. @ machining	S 12/01/10 AST002	- Drill holes in correct location as per Dwg. + TAP + SPEC Dwg. Due to P/L chipping Strip All parts + R.C. 12/01/10	12/01/10 12/01/10	S 12/01/10 AST002	S 12/01/10	S 12/01/10
		50 min Start Time 10:30 Temp: 3200F Finish Time: 11:10		Rework cost as per AST005 Plug incorrect holes with	12/01/12	S 12/01/10 AST002	S 12/01/10	S 12/01/10
		Acceptable to P/L per 50 min's 12/01/12						

NOTE: Date & initial all entries

# Picklist Print

Thursday, December 22, 2011 7:59:56 AM

Page 1

Work Order ID: 77847

Parent Item: D4571-1

Parent Item Name: Base

Start Date: 12/22/2011

Required Date: 12/28/2011

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP REV:A NEW ISSUE 11-12-21 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.500		Purchased	No				f	87.4000		4.4947368			
6061-T6 Bar 1.50 x 2.50													

Location	Loc Qty	Loc Code
MAT004	87.4	
103069	12	
107387	39.4	
16742	36	

us 12/28/28

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 77847
<b>Description:</b> <i>Peelal Lock</i>		<b>Part Number:</b> D4571-1
<b>Inspection Dwg:</b> D4571 <b>Rev:</b> RA1		<b>Page 1 of 1</b>

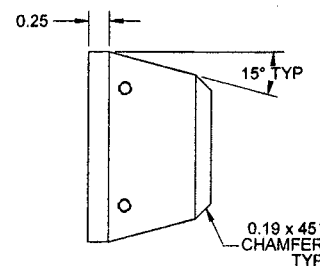
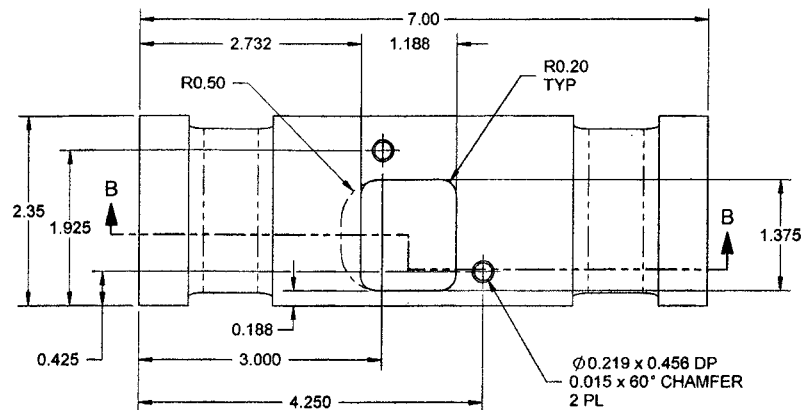
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.35	$\pm .03$	2.349	✓		Dial Caliper	3605
1.925	$\pm .01$	1.927	✓			
.425	$\pm .01$	.427	✓			
.188	$\pm .01$	.186	✓			
3.000	$\pm .01$	3.000	✓			
4.250	$\pm .01$	4.250	✓			
$\phi .219 \times .456$	$\begin{smallmatrix} +.005 \\ -.001 \end{smallmatrix} / \pm .01$	.270 / .454	✓			
1.375	$\pm .01$	1.379	✓			
7.000	$\pm .01$	7.002	✓		Digital Caliper	3607
1.188	$\pm .01$	1.191	✓			3605
2.732	$\pm .01$	2.733	✓			
1.50	$\pm .03$	1.495	✓			
.760	$\pm .01$	.757	✓			
.850	$\pm .01$	.850	✓			
.188	$\pm .01$	.187	✓			
.443	$\pm .01$	.450	✓			
$\phi .136 / 8-32$	$\begin{smallmatrix} +.005 \\ -.001 \end{smallmatrix}$	.135 / 8-32	✓			
5.800	$\pm .01$	5.797	✓			
3.700	$\pm .01$	3.700	✓			
1.850	$\pm .01$					
1.050	$\pm .01$	1.048	✓			
.25	$\pm .03$	.258	✓			

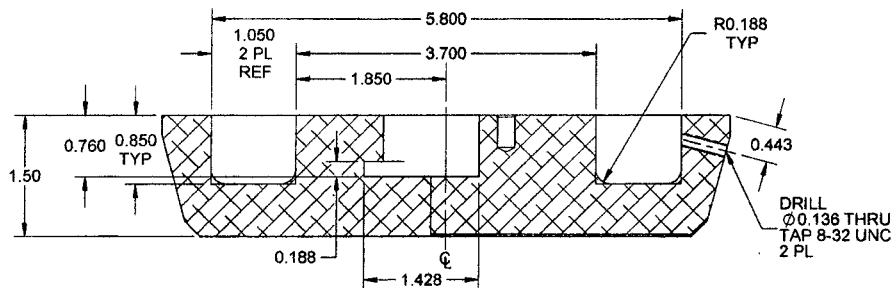
<b>Measured by:</b> <i>3612</i>	<b>Audited by:</b> <i>B.A</i>	<b>Preliminary Approval:</b>
<b>Date:</b> 11/12/28	<b>Date:</b> 12/01/02	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*10.04.15*

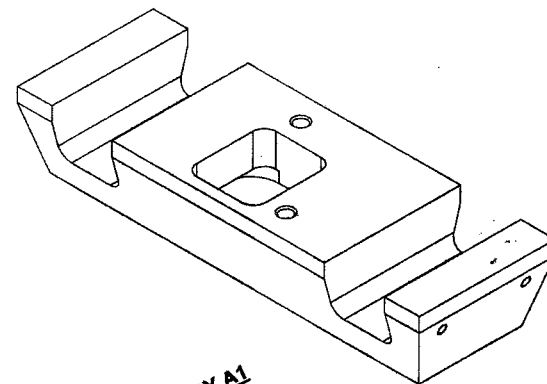


w/o 77847



**SECTION B-B**

DRILL  
Ø0.136 THRU  
TAP 8-32 UNC  
2 PL




**NOTES:**

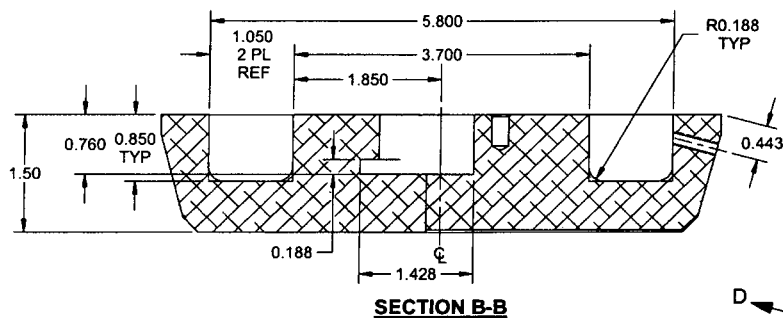
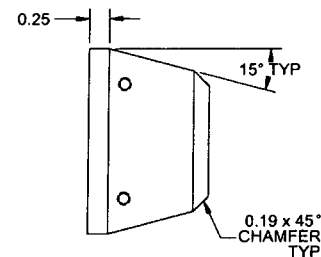
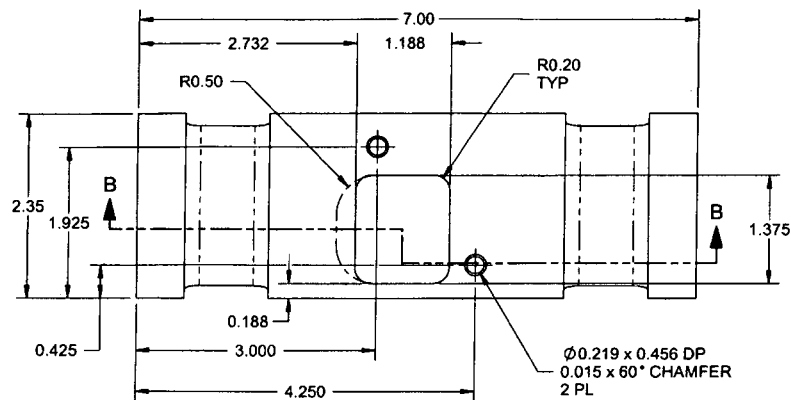
- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR  
ASTM B211 OR ASTM B221  
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

**D4203-1 BASE**

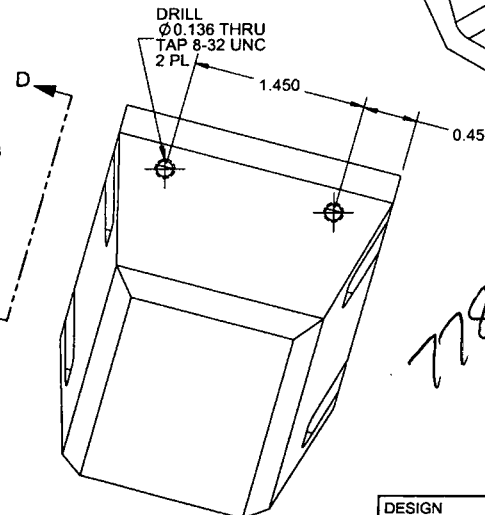
D4571-1

**PRELIMINARY A1**  
11.12.21 (RP)

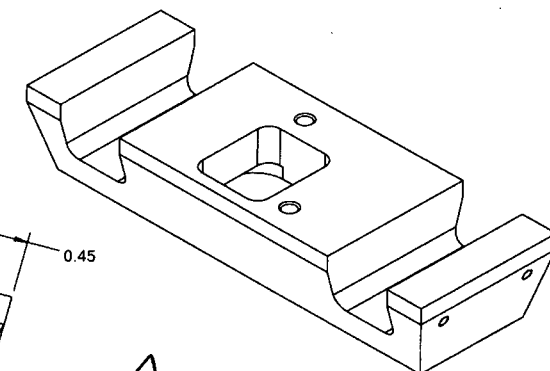
DESIGN	RP	<b>DART AEROSPACE LTD</b>	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. PA1
MFG. APPR.		D4571	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
DATE	11.12.21	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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**SECTION B-B**





**VIEW D-D**



**NOTES:**

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

**D4571-1 BASE**

DESIGN	RP	<b>DART AEROSPACE LTD</b>	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. A
MFG. APPR.		D4571	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
DATE	12.01.06	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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